

D3937-3 SHEET METAL BACKING STRIP

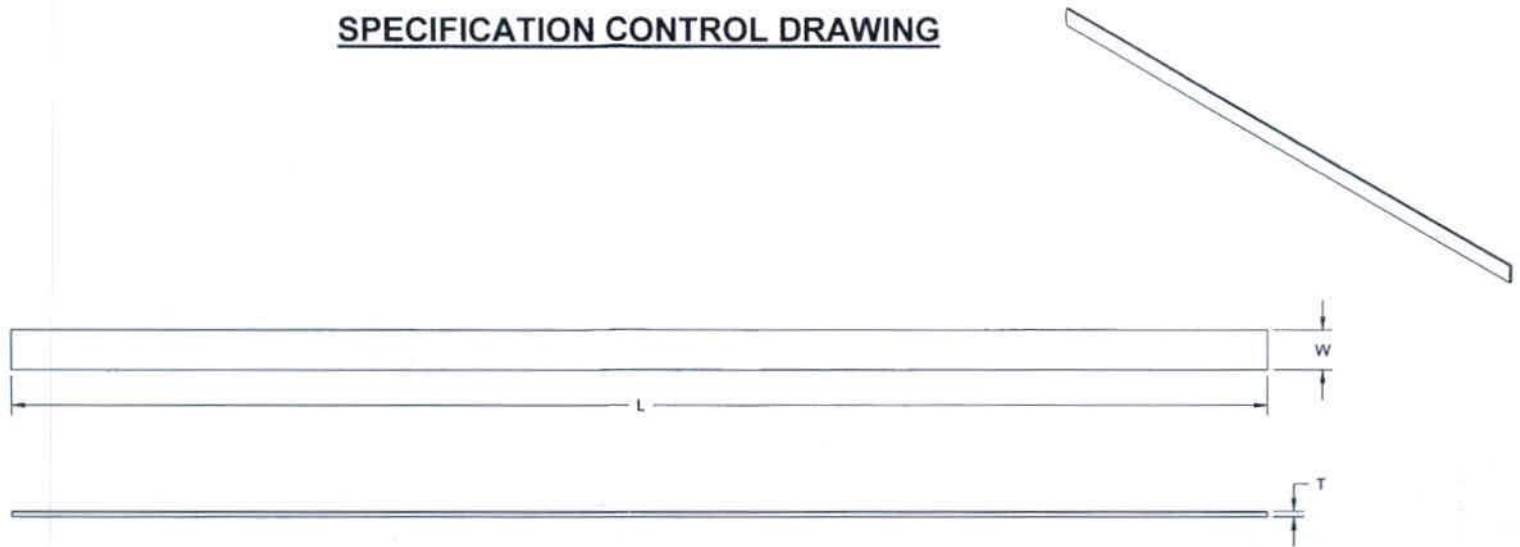
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.032 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

DESIGN	<i>AS</i>	DART AEROSPACE LTD	
DRAWN	<i>AS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>AS</i>	D3937	SHEET 3 OF 3
APPROVED	<i>AS</i>	TITLE	SCALE
DE APPR.	<i>AS</i>	LUMINESCENT STRIP	NTS
DATE	09.06.02	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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50772
RELEASED
2009-08-28
N

SPECIFICATION CONTROL DRAWING



D3937-1 LUMINESCENT STRIP

DART PART NUMBER	LENGTH "L"	WIDTH "W"	THICKNESS "T"	SUPPLIER	SUPPLIER PART NUMBER	WEIGHT
D3937-1	21.0	0.67	0.09	LUFTHANSA TECHNIK	PL88-990LH00	0.04 LBS

50712

RELEASED
2009-08-28

- NOTES:
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: SEE TABLE

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED	AS		DRAWING NO.	REV. A
MFG. APPR.	BE		D3937	SHEET 2 OF 3
APPROVED			TITLE	SCALE
DE APPR.			LUMINESCENT STRIP	NTS
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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3937-041	LUMINESCENT STRIP ASSEMBLY
2	1	D3937-1	LUMINESCENT STRIP
3	1	D3937-3	SHEET METAL BACKING STRIP

PEEL SELF-ADHESIVE BACKING FROM
D3937-1 LUMINESCENT STRIP.
ALIGN PART EDGES AND STICK TO
D3937-3 SHEET METAL BACKING STRIP

D3937-041 LUMINESCENT STRIP ASSEMBLY

50772
RELEASED
2009-08-28
MB

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3937-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

A	NEW ISSUE		09.06.02
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.02		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3937
TITLE LUMINESCENT STRIP
REV. A
SHEET 1 OF 3
SCALE NTS

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July 22, 2009 9:11:04 AM

11/07/22



Required Date: 7/23/09

Required Qty: 96.00

[illegible]

Work Order ID 50772

July 22, 2009 8:47:17 AM



Page 4

Item ID: D3937-041

Revision ID: A-Preliminary #09.07.22

Item Name: Photoluminescent Strips

Start Date: 7/23/09

Start Qty: 96.00

Required Date: 7/23/09

Req'd Qty: 96.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

180



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Memo

0.00

Work Order ID 50772

July 22, 2009 8:47:17 AM

Page 3

Item ID: D3937-041 #09.07.22
 Revision ID: A-Preliminary
 Item Name: Photoluminescent Strips

Accept

Setup Start

Stop

Start Date: 7/23/09 Start Qty: 96.00
 Required Date: 7/23/09 Req'd Qty: 96.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
 Work Center ID

Operation
 Description

Set Up/
 Run Hours

Draw
 Number

Draw
 Rev.

Plan
 Code

Accept
 Qty

Reject
 Qty

Reject
 Number

Insp.
 Stamp

150



Small Fab

Small Fab

Memo

1- Align part edges and stick strip to D3937-3 as per dwg

Eagle

0.00

0.00

240 X m.d 09/07/23

JUL 23 2009

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

Eagle

0.00

240
 JUL 23 2009

209023

170



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

Eagle

0.00

Delivered to Eagle

JUL 23 2009

Work Order ID 50772

July 22, 2009 8:47:17 AM



Page 2

Item ID: D3937-041

Revision ID: A-Preliminary *th 09.07.22*

Item Name: Photoluminescent Strips

Start Date: 7/23/09

Start Qty: 96.00

Required Date: 7/23/09

Req'd Qty: 96.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

N/A

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

Work Order ID 50772

July 22, 2009 8:47:17 AM

SPLIT



Page 1

Item ID: D3937-041

Revision ID: A-Preliminary

Item Name: Photoluminescent Strips

Start Date: 7/23/09

Required Date: 7/23/09

Reference:

Start Qty: 96.00

Req'd Qty: 96.00

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100



Waterjet

FLOW CNC Waterjet

0.00

Memo

0.00

1-Cut as per Dwg D3937 (Make D3937-3)

Dwg Rev:

Prog Rev:

2-Debur if necessary

Draw on D3937-3

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

B50557

Picklist Print

July 22, 2009 9:11:04 AM

Page 1

Work Order ID: 50772

Parent Item: D3937-041RevA-~~Photoluminescent Strips~~

Parent Item Name: Photoluminescent Strips

Comments:

Start Date: 7/23/09

Required Date: 7/23/09

Start Qty: 96.00

Required Qty: 96.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3937-1RevA-PRELIM		Manufactured	No				Each	0.0000	1.0000			
Luminescent Strip								50073				
D3937-3A-Prelim		Manufactured	No				Each	0.0000	1.0000			
Backing Strip								50557				

Work Order ID 50772

July 22, 2009 8:47:17 AM



Page 4

Item ID: D3937-041

Revision ID: A-~~Preliminary~~ #09.07.22

Item Name: Photoluminescent Strips

Start Date: 7/23/09 Start Qty: 96.00

Required Date: 7/23/09 Req'd Qty: 96.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

180



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Memo

0.00

C of C only int. C approved.

09/09/01

ABRORAT
ENGINEERING

Work Order ID 50772

July 22, 2009 8:47:17 AM



Page 3

Item ID: D3937-041
 Revision ID: A-Preliminary
 Item Name: Photoluminescent Strips

Accept



Setup Start



Stop



Start Date: 7/23/09 Start Qty: 96.00
 Required Date: 7/23/09 Req'd Qty: 96.00



Cust Item ID:
 Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
 Work Center ID

150



Small Fab

Small Fab

Operation
 Description

Set Up/
 Run Hours

Draw
 Number

Draw
 Rev.

Plan
 Code

Accept
 Qty

Reject
 Qty

Reject
 Number

Insp.
 Stamp

Memo

1- Align part edges and stick strip to D3937-3 as per dwg

Eagle

0.00

0.00

240 X

m. 09/07/23

JUL 23 2009

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

Eagle

0.00

JUL 23 2009

ENGINEERING
 APPROVAL

09/07/23

170



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

Eagle

0.00

Delivered to Eagle

JUL 23 2009

W 09.07.24

Work Order ID 50772

July 22, 2009 8:47:17 AM



Page 2

Item ID: D3937-041

Revision ID: A-Preliminary # 09.07.22

Item Name: Photoluminescent Strips

Start Date: 7/23/09

Start Qty: 96.00

Required Date: 7/23/09

Req'd Qty: 96.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

Handwritten signature/initials

1000
1000

PRELIMINARY ISSUE

SPLIT

Work Order ID 50772 - 2

July 22, 2009 8:47:17 AM

Page 1

Item ID: D3937-041 ~~09.07.22~~

Revision ID: A-~~Preliminary~~

Item Name: Photoluminescent Strips

Start Date: 7/23/09 Start Qty: ~~80.00~~ 32

Required Date: 7/23/09 Req'd Qty: ~~80.00~~

Reference:

Accept

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100



Waterjet

FLOW CNC Waterjet

0.00

Memo

0.00

1-Cut as per Dwg D3937 (Make D3937-3)

Dwg Rev:

Prog Rev:

2-Deburr if necessary

Date on D3937-3

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

B 50557